

Work Order ID 50044

July 5, 2009 1:31:25 PM



Page 1

Item ID: D412-664-203

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-664-243

D

0.00

100



DC

Document Control

Memo

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

for MF 09/07/07

S 09/07/07

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

09/17/16 U

120

0.00



CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

MS 09-07-09

B 50044

Work Order ID 50044

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Page 2

Item ID: D412-664-203

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Revision ID: D

Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00

Required Date: 16/07/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

1

0

07-07-10

140

0.00



Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

MS
09-07-14
(15)

-Awmg-7-14 (1)

Work Order ID 50044



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Item ID: D412-664-203

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Revision ID: D

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Start Date: 06/07/2009 Start Qty: 1.00



Cust Item ID:

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Outsource process - NDT per QSI038 4.1

0.00



Outsource2

Memo

0.00

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 10094 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

CL 07/07/14 ①

190

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

PC 9/7/12 ①

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BT 09-07-20

Work Order ID 50044

July 6, 2009 1:31:25 PM

Page 5

Item ID: D412-664-203

Accept

Revision ID: D

Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00

Required Date: 16/07/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Spray Painting per QSI005 4.2

0.00

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 10:30

Finish Time: 11:30

PAINT:

Start Time: 3:06

Finish Time: 4:20

⇒ m 09 07 20 ①

220

QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

4T 07-07-21

Work Order ID 50044

July 6, 2009 1:31:25 PM

Page 6

Item ID: D412-664-203

Accept

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Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00

Required Date: 16/07/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/17/09 1050

240

0.00



Crosstubes

Memo

0.00

Crosstubes

Assemble as per Dwg D412-664-203

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 111249

Expiry Date: 02/2010

3-Install clamps as per Dwg D212-664-203 using installation jig DT9024 with 0.010 thick brass shims on both chafing shield (D3189-1). Torque clamps to 80-100 in lb.

⇒ ml 09 07 21 ①

ml 09 07 22 ①

Work Order ID 50044

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Item ID: D412-664-203

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC5- Inspect part completeness to step on W/O

0.00

2) 8 02/07/07



QC

Memo

0.00

Quality Control

④

f

260

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/7/07 RDS

270

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

⇒ 8 02/07/07

④

f

Work Order ID 50044

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Page 8

Item ID: D412-664-203

Accept



Setup Start



Revision ID: D

Stop



Item Name: Crosstube Aft

Start Date: 06/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 16/07/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

280

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27
for application time & date *****

Time & date of packaging: July 27, 2009 @ 2:00pm

Location: [Signature]
PPP Rev: [Signature]

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

9/17/27 @ Sep

09/07/28 [Signature]

MF 09-07-28

Picklist Print

Page 1

July 6, 2009 1:31:24 PM

Work Order ID: 50044

Parent Item: D412-664-203RevD

Parent Item Name: Crosstube Aft

Comments:

Start Date: 06/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D412-664- 203TRNRevD		Manufactured	No			110	Each	2.0000	1.0000			



Crosstube Turning Detail



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FG 2

48396 1

48397 1

D3595-063-570RevA Manufactured No



RUBBER CUSHION

230 Each 93.0000 4.0000



Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 12

37971 4

42243 8

Main Warehouse

ST 81

42243 21

45509 60

1 MB 09-07-09

ml.m 09 07 21

Picklist Print

July 6, 2009 1:31:24 PM

Work Order ID: 50044

Parent Item: D412-664-203RevD

Parent Item Name: Crosstube Aft

Comments:

Start Date: 06/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2856-600RevA		Manufactured	No			230	f	472.3400	1.7684			
Abrasion Strip												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	472.34	
24328	6.73	
25656	87.77	
26650	8.23	
36398	154.55	
37668	215.06	

(2X) D2856-600 (Cut to 10.090")

D2896-1RevU/R Manufactured No



Support

D3189-1RevB Manufactured No



Chafing Shield

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	4	
36065	4	
Main Warehouse		
ST	30	
43927	9	
47777	21	

ml ml 09 07 20

359
B43909 ml 09-07-21

ml ml 09 07 21

July 6, 2009 1:31:25 PM

Shop Packet Print

Picklist Print

July 6, 2009 1:31:25 PM

Work Order ID: 50044

Parent Item: D412-664-203RevD

Parent Item Name: Crosstube Aft



Comments:

Start Date: 06/07/2009

Required Date: 16/07/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-28		Purchased	No			230	Each	156.0000	4.0000			
												
Clamp(per MIL-DTL-8783C)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	5	
105884	5	
Main Warehouse		
ST	151	
106864	5	
108466	9	
108847	7	
109181	14	
109965	16	
111281	50	
111734	50	

mm 09 07 21

MS21920-30		Purchased	No			230	Each	109.0000	2.0000			
												
clamp(per MIL-DTL-8783C)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	109	
107600	9	
109181	50	
111258	50	

mm 09 07 21

Picklist Print

July 6, 2009 1:31:25 PM

Work Order ID: 50044

Parent Item: D412-664-203RevD

Parent Item Name: Crosstube Aft

Comments:

Start Date: 06/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN6-40A		Purchased	No			260	Each	31.0000	4.0000			
---------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

111424

31

31

AN6-41A		Purchased	No			260	Each	67.0000	2.0000			
---------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST

109371

111605

67

17

50

111424 9/4/07 SD

109371 9/4/07 @ Sp

Picklist Print

July 6, 2009 1:31:25 PM

Work Order ID: 50044

Parent Item: D412-664-203RevD

Parent Item Name: Crosstube Aft

Comments:

Start Date: 06/07/2009

Required Date: 16/07/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD616

x18

Purchased

No

260

Each

484.0000

18.0000



Washer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

484

107242

3

107959

6

109371

8

110704

23

111193

18

111607

426

MS21042L6

26

Purchased

No

260

Each

803.0000

6.0000



Nut



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

803

105077

22

110002

275

111548

100

111578

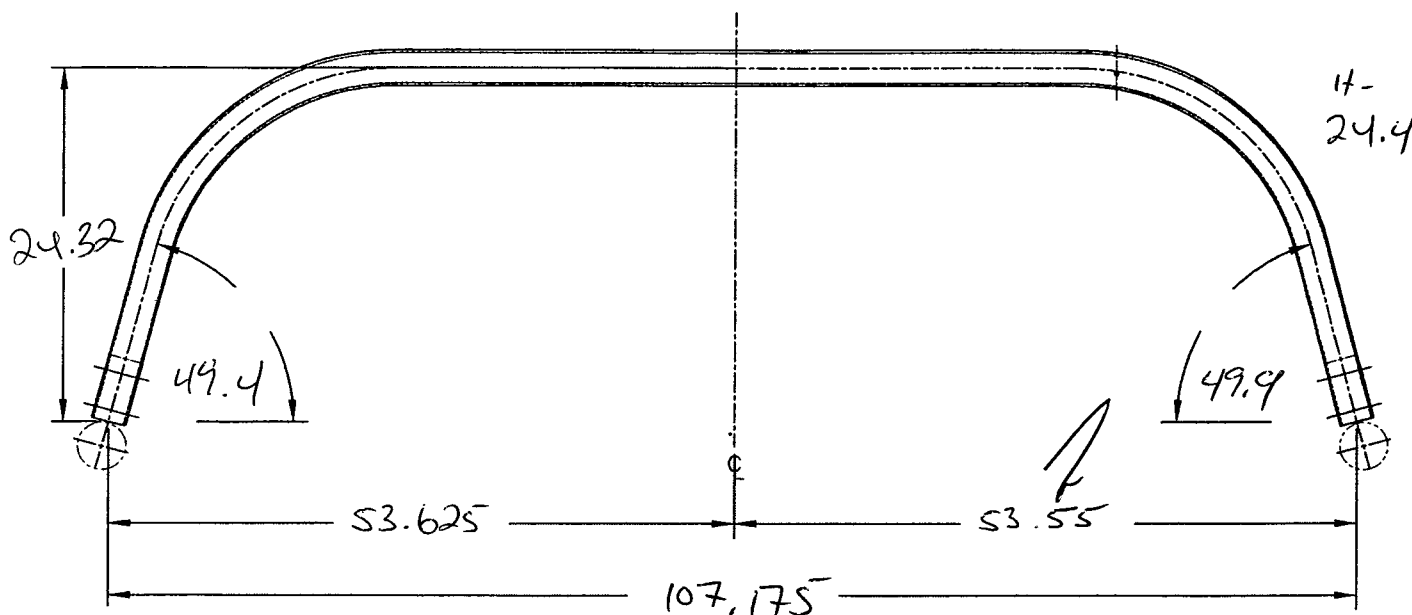
400

19099

6

DART AEROSPACE LTD		Work Order:	50044
Description: Crosstube High Aft (412)		Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	 QS1012
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

RELEASE07.04.24 **[Signature]**

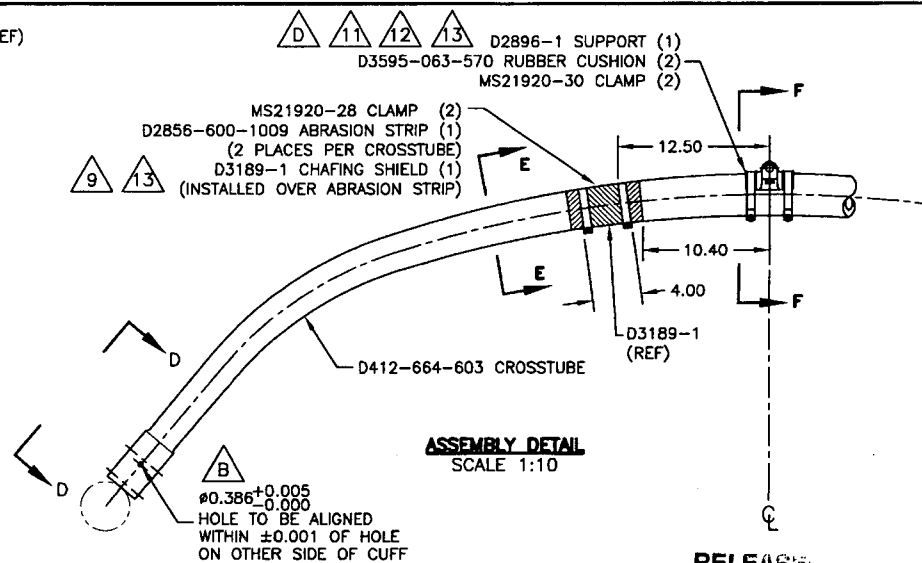
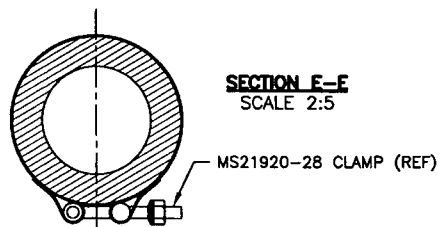
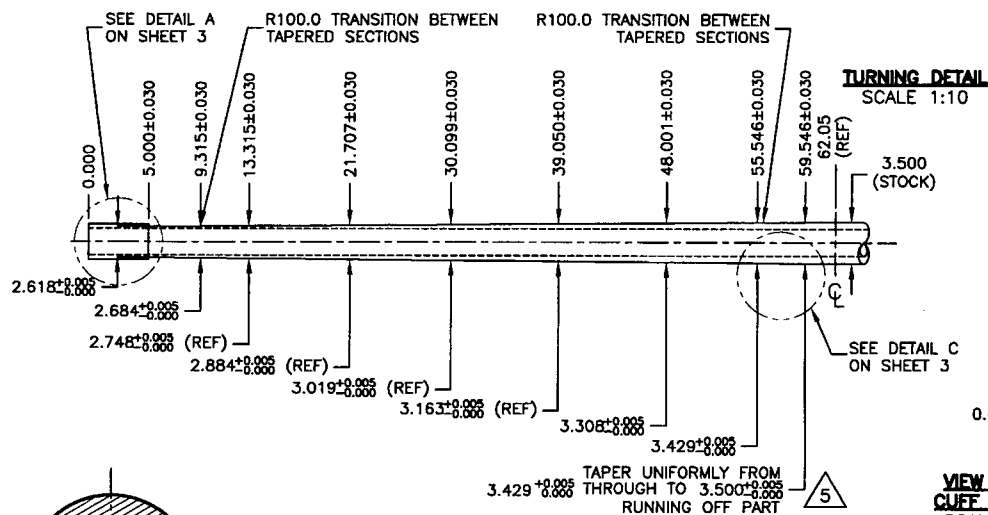
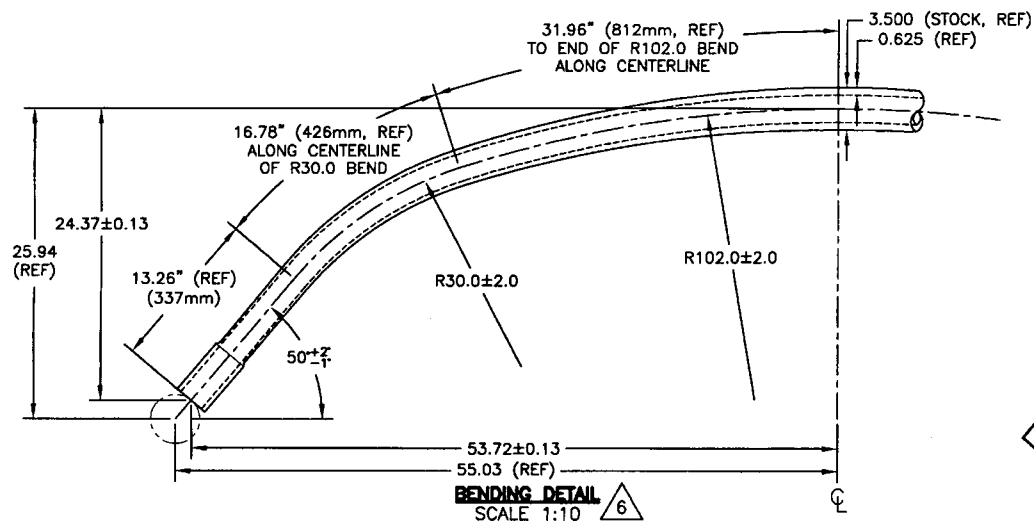
Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

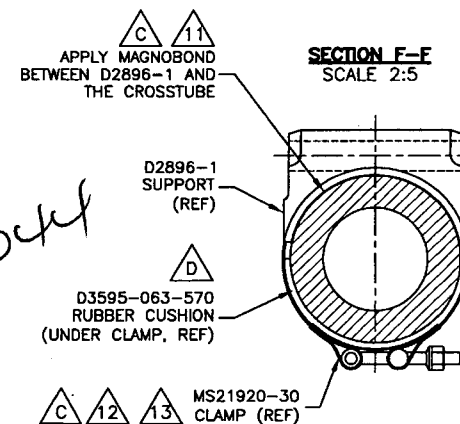
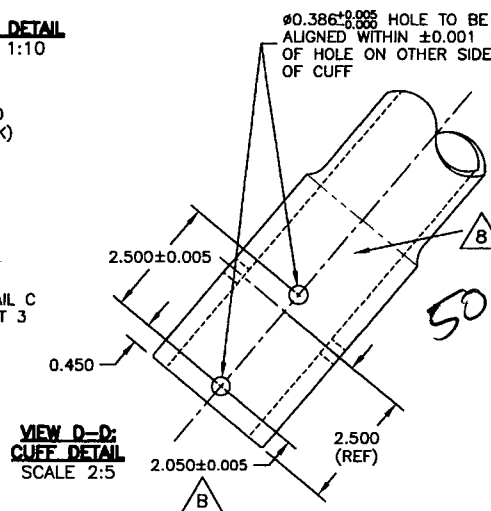
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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RELEASED
07 04 24

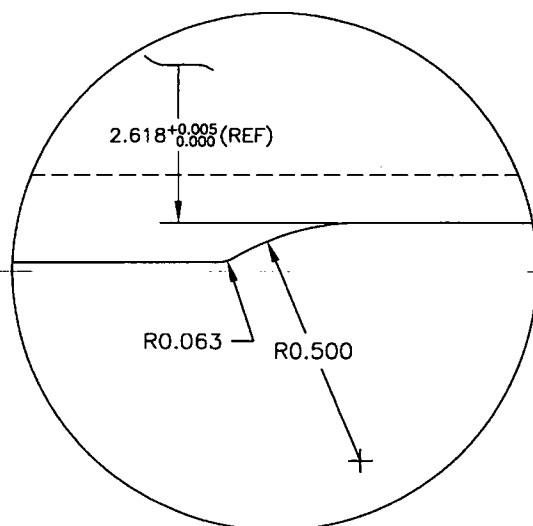
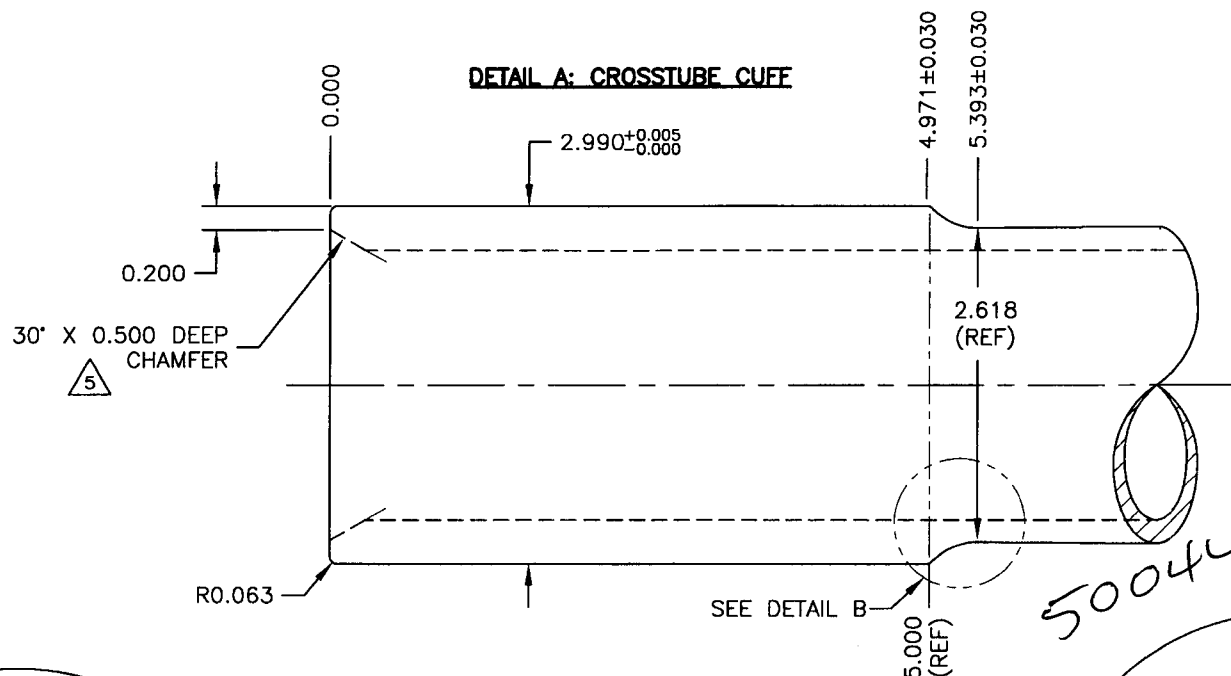


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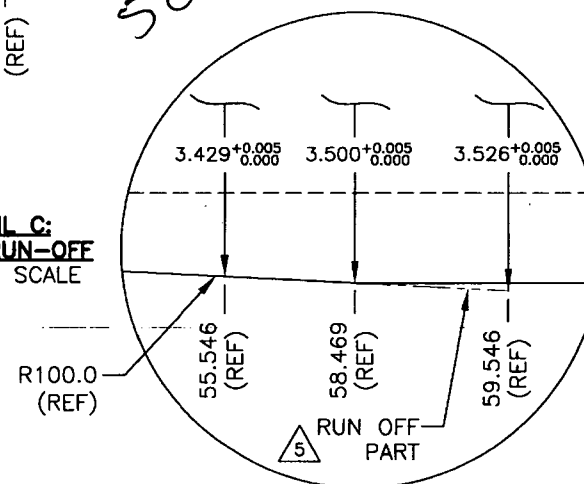
DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	97	APPROVED	PH	DRAWING NO. D412-664-243	REV. D SHEET 2 OF 3
DATE	07.03.09	TITLE	CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE	1:10

RELEASED
07-04-244P
REF ECN 489



DETAIL B: CUFF TRANSITION
SCALE 4:1

DETAIL C: TAPER RUN-OFF
NOT TO SCALE



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DESIGN

PH

DRAWN BY

PH

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

CHECKED

J

APPROVED

J

DRAWING NO.
D412-664-243

REV. D
SHEET 3 OF 3

DATE

07.03.09

TITLE

CROSSTUBE ASSEMBLY (412 HI AFT)

SCALE

1:1



LIQUID PENETRANT TEST REPORT

P- 14943

CLIENT DART AEROSPACE DATE July 16-2009 PAGE 1 OF 1
ATTENTION LINDA/CHWTEL ACUREN JOB NO. 188-09-001468 TIME AM ☒ PM ☐
ADDRESS 1270 ABELDEEN ST. PO/VO No. —
HAWKESBURY, ON. K6H 1k7 WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON CROSS TUBES
ITEM(S) EXAMINED 6 - X - TUBES

JOB DESCRIPTION PROCEDURE No. LT-XXX REV./DATE TECHNIQUE No. LT-XXX-XXX REV./DATE
PART No. MATERIAL Aluminum THICKNESS —
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABNO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N — CAL DUE DATE DEC 8-2009
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

Work order #
1 - 50081 ✓
1 - 50094 ✓
1 - 50045 ✓
1 - 50019 ✓
1 - 50038 ✓
1 - 50044 ✓
NO RELEVANT INDICATIONS
WERE FOUND ON THESE
SIX CROSS TUBES

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Sean Tittley DTR # E-27929
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:
NAME (PRINT): Mike Jetterson NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL II SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. 6066 CGSB REG. NO. —

32.11 PARTS LISTS**32.11.1 HIGH GEAR CROSSTUBES**

Item	-101	-201	-203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21042-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21042-30)
23		4		AN6-40A	BOLT
24		2		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
31			2	* D2856-600-1009	ABRASION STRIP
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21042-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

*REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE
NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AA
SKIDTUBES.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries